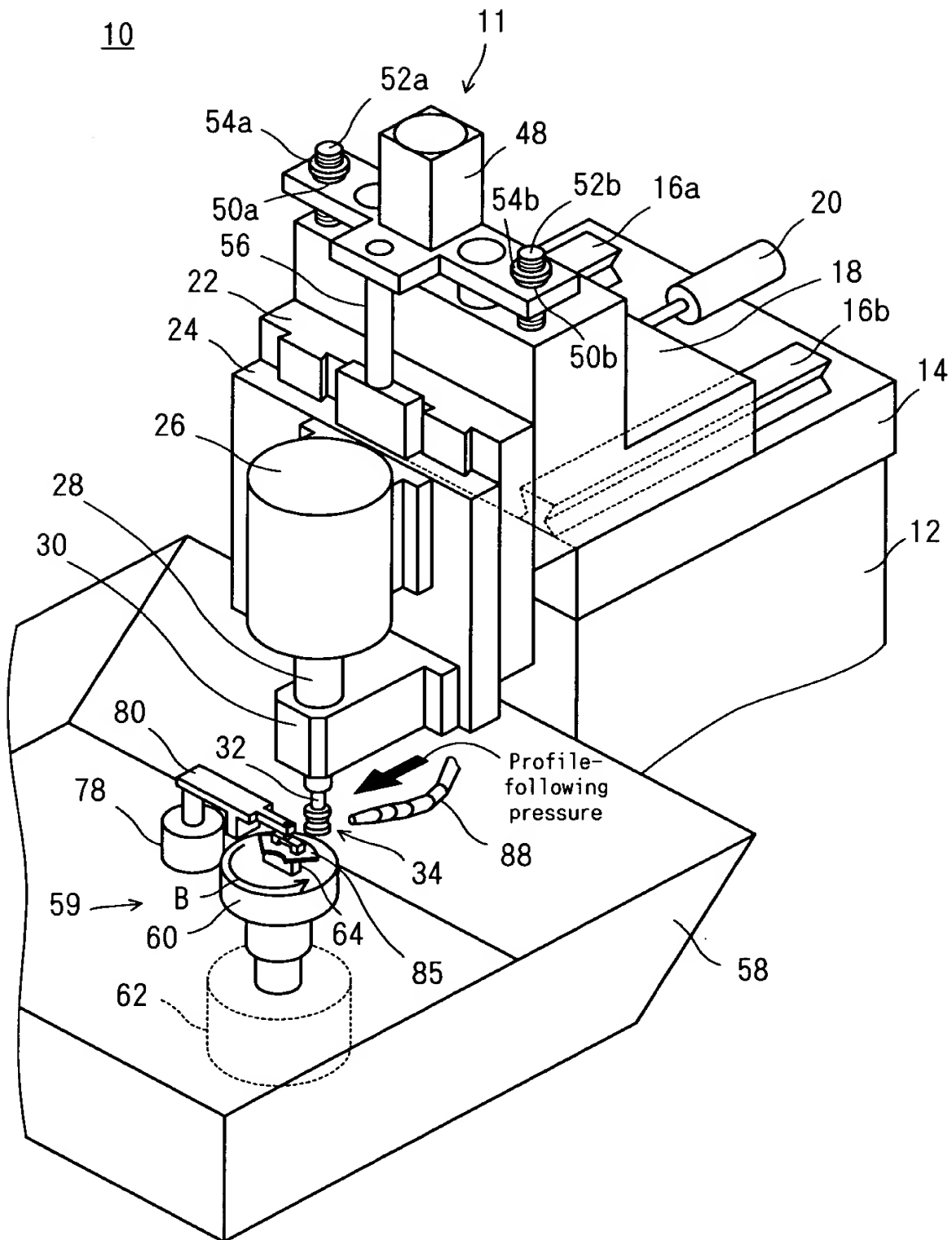


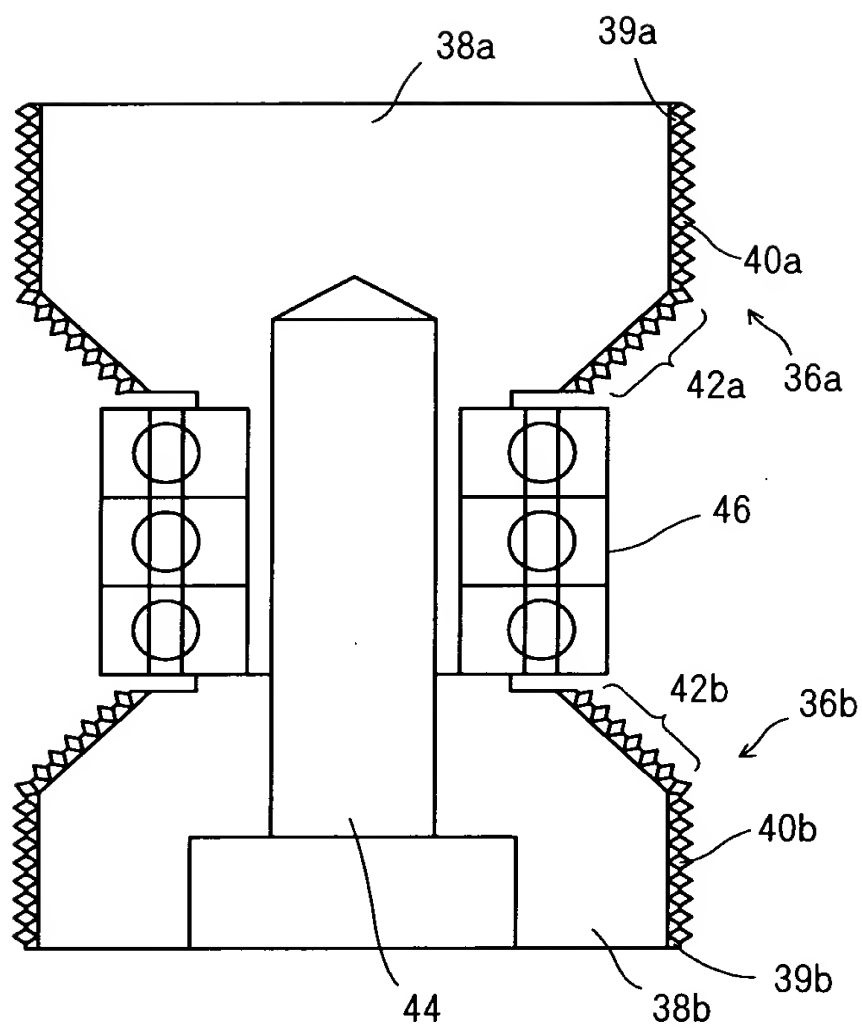
FIG. 1



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FIG. 2

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FIG. 3

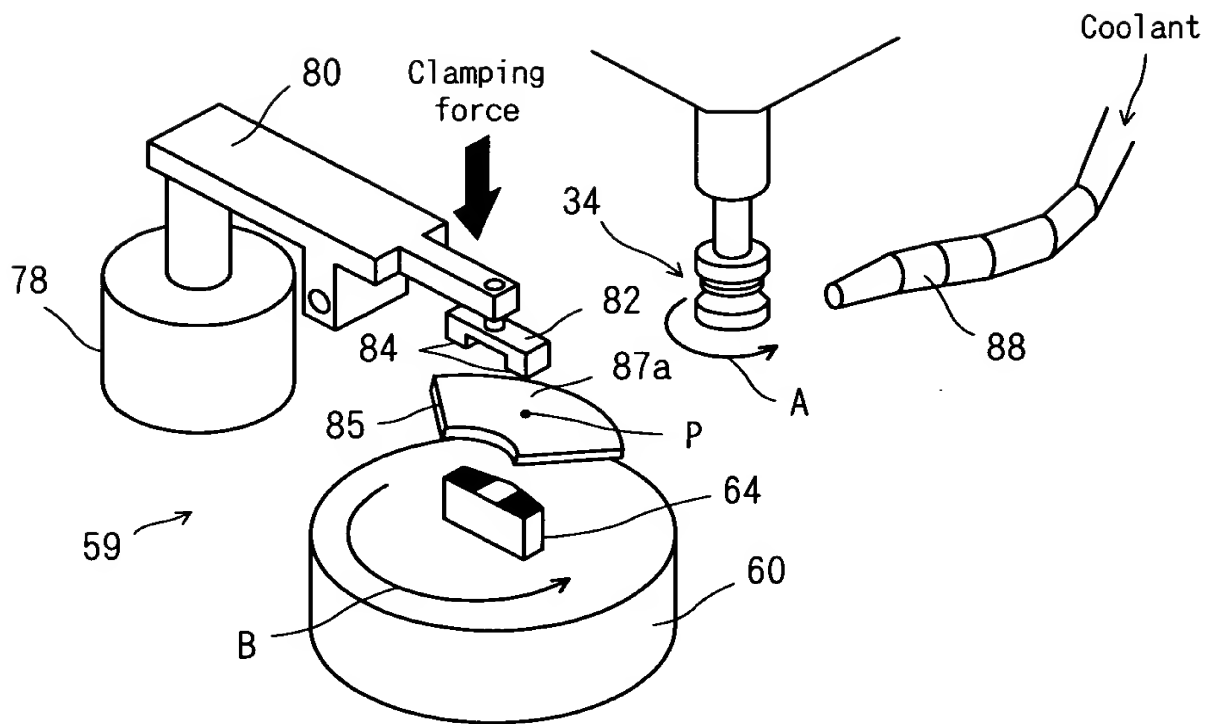


FIG. 4A

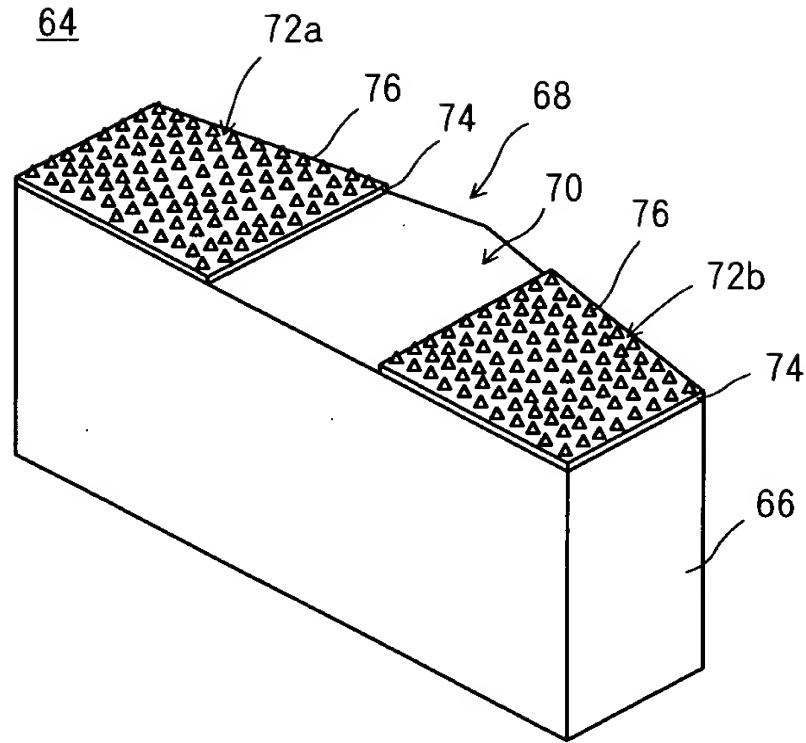


FIG. 4B

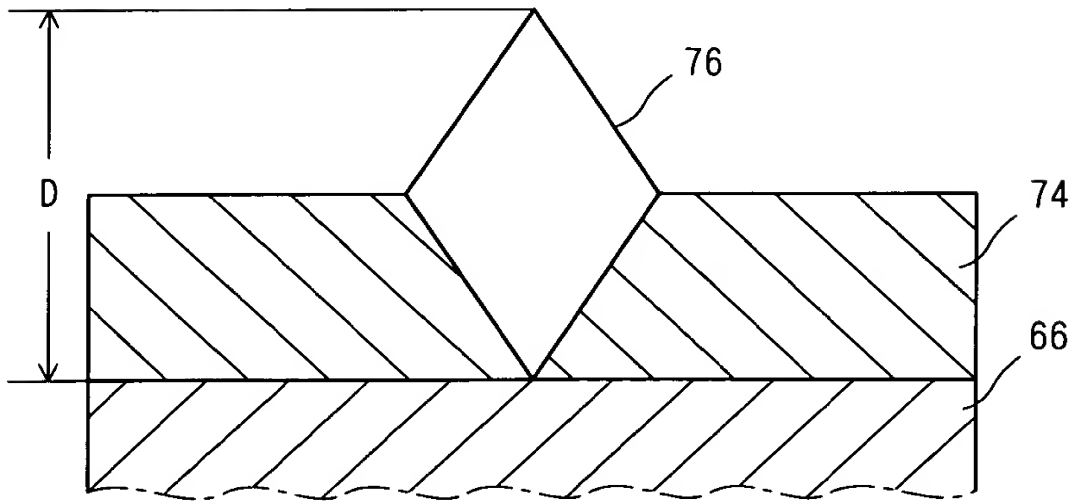


FIG. 5A

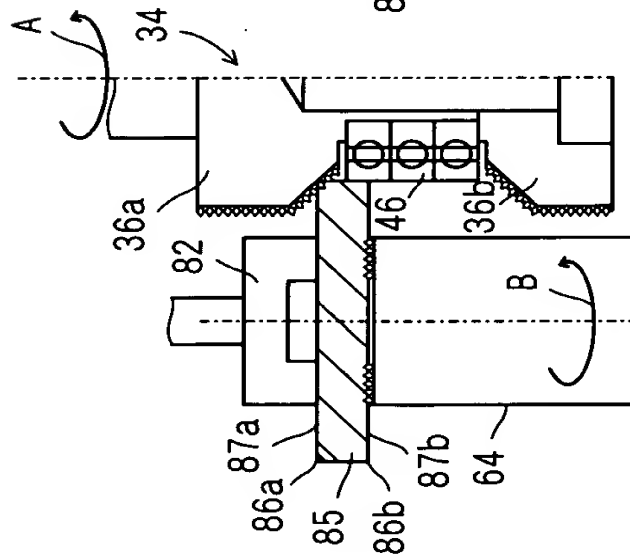


FIG. 5B

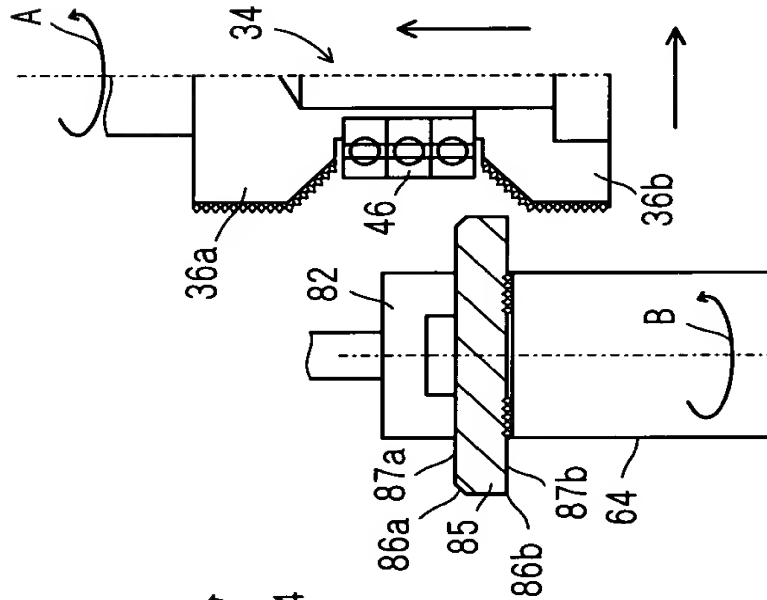


FIG. 5C

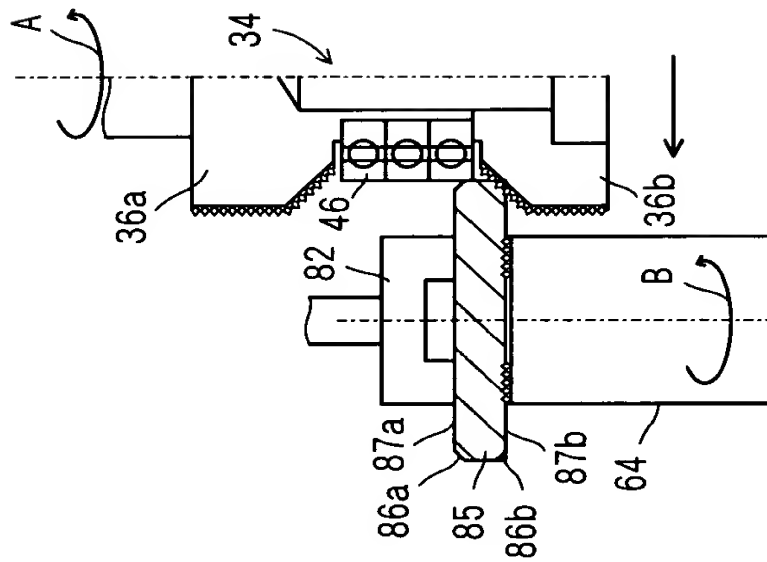
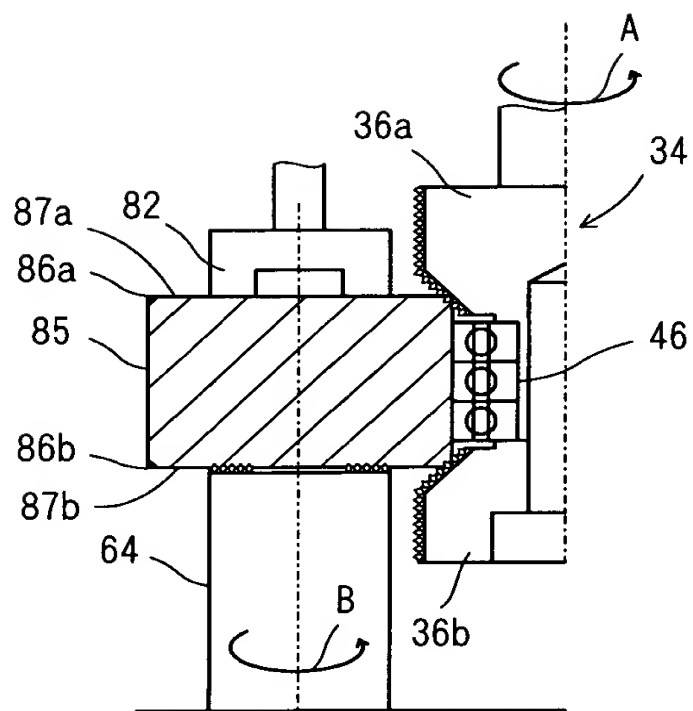


FIG. 6



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FIG. 7A

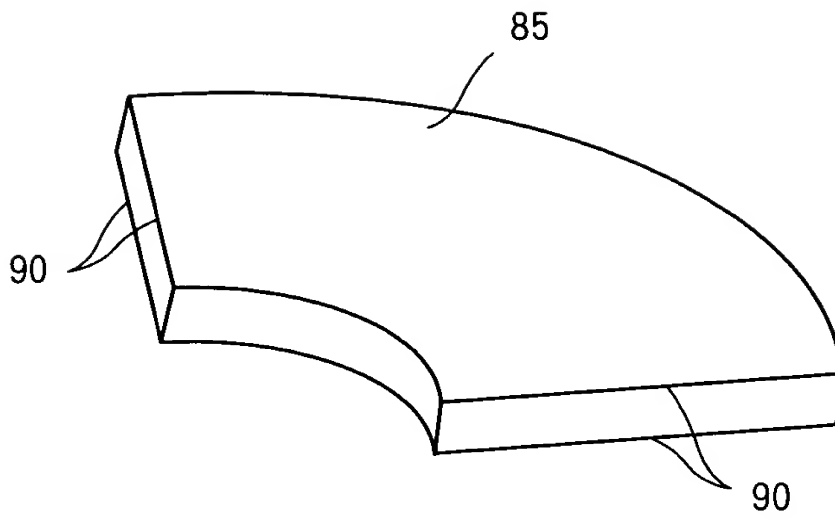
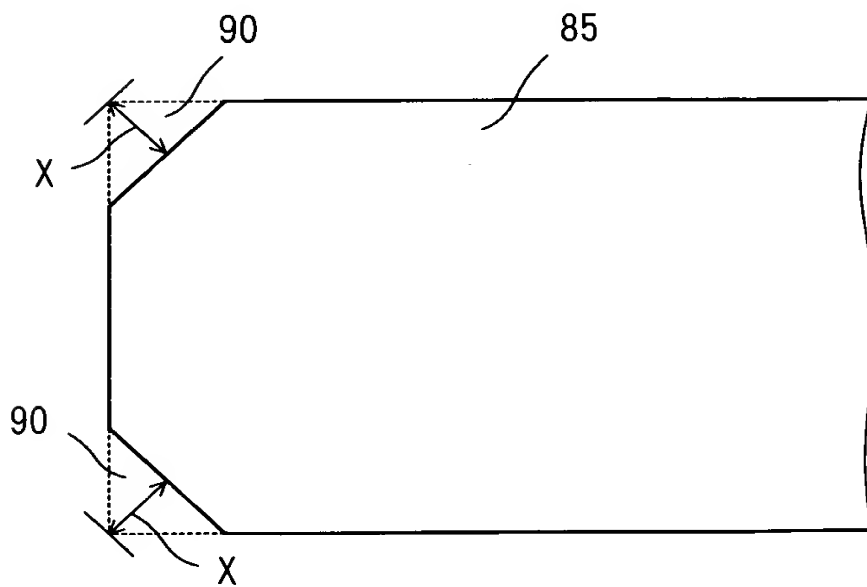


FIG. 7B



F I G. 8 A

Relationship between Grinding Stone  
Rotating Speed and Chipping

Grinding stone rotating speed (rpm)	500	1000	2000	3000	4000	5000	6000	7000
Grinding stone circumferential speed (m/min)	31.4	62.8	125.6	188.4	251.2	314	376.8	439.6
Number of chippings (Diameter $\geq 1\text{mm}$ )	20	15	10	8	5	10	35	Seizure

F I G. 8 B

